

Work Order ID 68785

Thursday, April 21, 2011 8:06:01 AM



Page 1

Item ID: D412-698-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Handle

Start Date: 4/20/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-013CHG001

-Sulcu/28

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/27 SP (30) Ph →

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulcu/28

(73)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-688-013 PAR #: N/A Fault Category: Production NCR: Yes No DQA: Yes Date: 11.05.03
 Resolution: re-work Disposition: re-work QA: N/C Closed: Yes Date: 11/05/04

NCR: <u>68785</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/04/26</u>	<u>#110</u>	<u>Amounts missing under Qty Per kit column. R.C work order is incorrect</u>	<u>CP</u> <u>11/04/26</u> <u>BS/04/26</u>	<u>-Fix/Adjust to ensure the correct amount is under Qty Per kit. to be picked.</u> <u>Add copy of form to person that who is fixed !!</u>	<u>W</u> <u>11/04/29</u>	<u>S</u> <u>11/04/29</u>	<u>CP</u> <u>11/04/28</u> <u>BS/04/28</u>	<u>S</u> <u>11/04/28</u>
								<u>S</u> <u>11/04/28</u>

NOTE: Date & initial all entries

Work Order ID 68785

Thursday, April 21, 2011 8:06:02 AM



Page 2

Item ID: D412-698-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Handle

Start Date: 4/20/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-013 Location: 10

Reva

11/4/28

308

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

11/4/28

MF
11-04-28

• Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:06:09 AM

Page 1

Work Order ID: 68785

Parent Item: D412-698-013

Parent Item Name: Door Handle



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416L ! Washer	NAS1149D0416J	Purchased	No				Each	5.0000	16 	24			
<div>Location</div> <div>FP-B</div> <div>110153</div>													
<div>Loc Qty</div> <div>5</div> <div>5</div>													
<div>Loc Code</div> <div></div> <div></div>													
D3203-1 Handle		Manufactured	No				Each	18.0000	14 	12			
<div>Location</div> <div>ST240</div> <div>65003</div>													
<div>Loc Qty</div> <div>18</div> <div>18</div>													
<div>Loc Code</div> <div></div> <div></div>													
D3220-041 Doubler Assembly		Manufactured	No				Each	3.0000	1 	3			
<div>Location</div> <div>ST177</div> <div>65001</div>													
<div>Loc Qty</div> <div>3</div> <div>3</div>													
<div>Loc Code</div> <div></div> <div></div>													
D3220-042 Doubler Assembly		Manufactured	No				Each	4.0000	1 	3			
<div>Location</div> <div>ST177</div> <div>65002</div>													
<div>Loc Qty</div> <div>4</div> <div>4</div>													
<div>Loc Code</div> <div></div> <div></div>													

1114103

12

12

3

3

11/4/27

3

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:06:09 AM

Page 2

Work Order ID: 68785

Parent Item: D412-698-013

Parent Item Name: Door Handle

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 3.00

Required Qty: 3.00

D3220-3

Manufactured No

Each

12.0000



Doubler



42 6
SP

Location

Loc Qty

Loc Code

ST180a

12

65081

12

Each

5,341.000

MS21042L4

Purchased

No



Nut



6
24
SP

Location

Loc Qty

Loc Code

ST300

5341

116188

341

116823

2000

117441

3000

Each

153.0000

MS24694-S98

Purchased

No



Screw



46 48
114127 SP (30)

Location

Loc Qty

Loc Code

ST289A

153

116582

153

48

Thursday, April 21, 2011 8:06:09 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01

Single-Level Bill

Friday, April 29, 2011 9:07:41 AM

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Criteria : Item ID: d412-698-013, All Product Families, All Item Types, All Categories, All Buyers/Planners, Effective Start Date: 4/29/2011.

Single Level Bill of Material Standard Report As of: 4/29/2011

Parent Item ID D412-698-013 Unit Measure Each Replacement Item ID

Item Name Door Handle

Item ID	Item Name	Replacement Item ID	Qty/ Assy	Unit Measure	Eff. Start Date	Eff. Stop Date
BOM Type Production						
AN960JD416L	Washer	NAS1149D0416J	8.0000	Each	6/24/2009	
D3203-1	Handle		4.0000	Each	12/5/2009	
D3220-041	Doubler Assembly		1.0000	Each	12/5/2009	
D3220-042	Doubler Assembly		1.0000	Each	12/5/2009	
D3220-3	Doubler		2.0000	Each	12/5/2009	
MS21042L4	Nut		8.0000	Each	6/24/2009	
MS24694-S98	Screw		16.0000	Each	6/24/2009	

